

Date: Tuesday, 15/08/2006 7:19:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B HIGH GEAR WEB	
Job Number	: 28178		Part Number	: D26543	
Estimate Number	: 10455		Drawing Number	: D2654 REV E1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 15/08/2006 S.O. No. : N/A		Drawing Revision	: E1	
Prsh't Rev.	: NC		Material	: P/M	
First Issue	: N/A		Due Date	: 31/08/2006	
Previous Run	: 27964		Qty:	4 Um: Each	
Written By	: <u> </u>				
Checked & Approved By	: <u> </u>				
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D26005108	Extrusion 'I Beam' thin		
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)		
Pick:	Qty	Part Number	Description	Batch
	1	D2600-5	Web	<u>B24410 PT 06-08-17</u>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1		
Comment:	LANDING GEAR RESOURCE 1			
	1-Cut D2600-5 to length as per Dwg D2654 <u>PT 06-08-17</u>			
	2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 <u>PT 06-08-17</u>			
	3-Using the uni-bit, open holes to finish size as per Dwg D2654 <u>PT 06-08-17</u>			
	4-Deburr holes and ends <u>PT 06-08-17</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment:	INSPECT WORK TO CURRENT STEP			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
Comment:	HAND FINISHING RESOURCE #1			
	Chemical Conversion Coat as per QSI 005 4.1 <u>PT 06-08-17</u>			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:35 AM
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Process Sheet

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Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 28178

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 06-08-17 4



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Pm 06-08-17 4

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/18

Job Completion



U 06-08-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

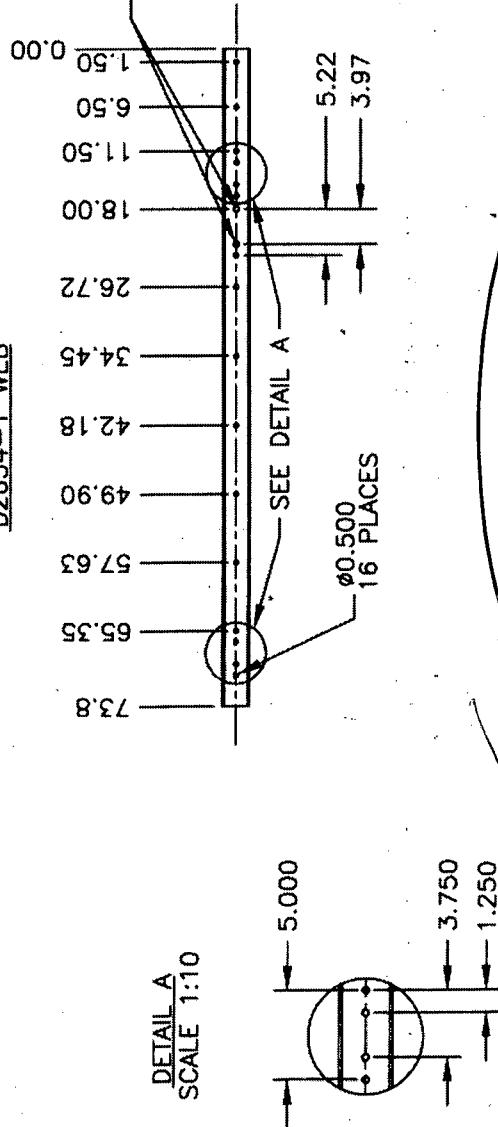
NOTE: Date & initial all entries

DART

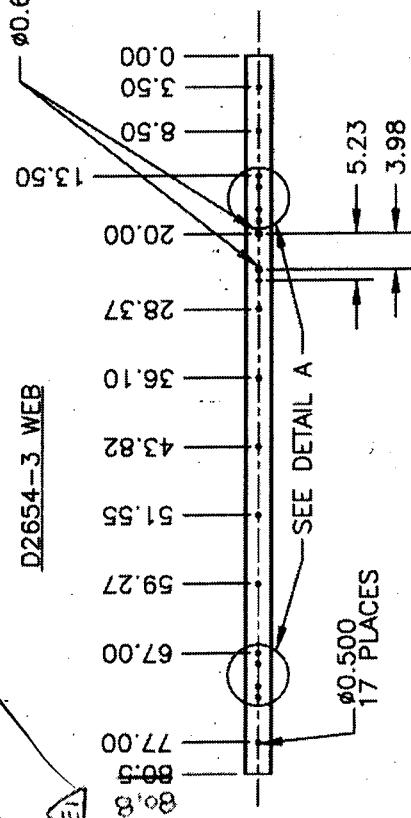
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB SCALE 1:20
04.05.26		

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB

**REFERENCE ONLY**

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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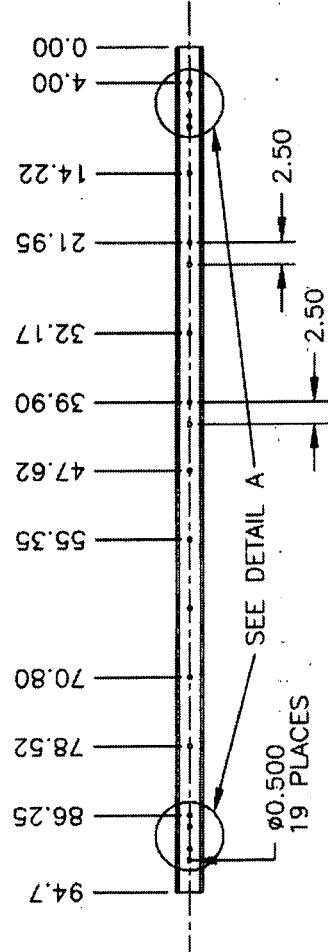
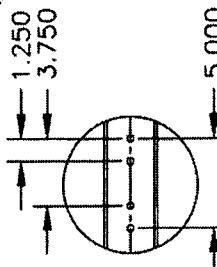
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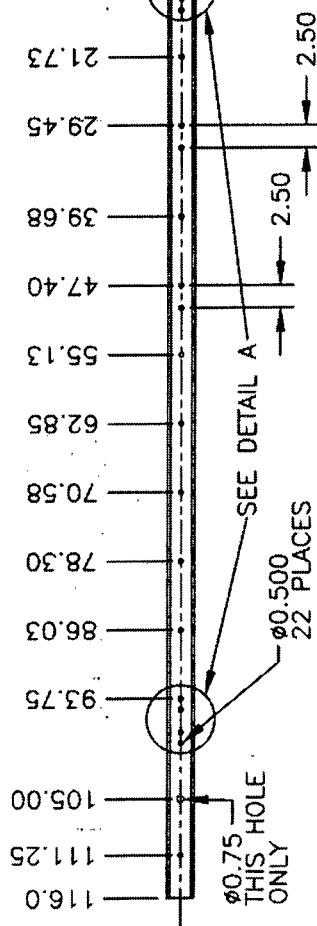
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CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 2 OF 2
DATE		TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB

DETAIL A
SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

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